

Customer	:	CU-DAR001 Dart Helicopters Services	Drawing Name	:	WEARSHOE
Job Number	:	33440			
Estimate Number	:	12729			
P.O. Number	:	N/A	Part Number	:	D353539
This Issue	:	7/9/2007	S.O. No.	:	N/A
Prsht Rev.	:	NC	Drawing Number	:	D3535 UNDER REVIEW
First Issue	:	N/A	Project Number	:	N/A
Previous Run	:	32412	Drawing Revision	:	A/B PH
			Type	:	SMALL /MED FAB
			Drawing Revision	:	N/A 02.07.10
			Material	:	N/A
			Due Date	:	7/16/2007
Written By	:	[Signature]	Qty:		10 Um: Each
Checked & Approved By	:	[Signature]			
Comment	:	Est Rev.A New Issue 07-02-15 JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0 M304S20GA 304/316 .040 Sheet



Comment: Qty.: 0.9986 sf(s)/Unit Total : 9.9855 sf(s)

304/316 .040 Sheet

(M304S20GA)

Batch: M10506

LB 07-07-21

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET CHECK FLAT PATTERN REV.

1-Cut as per Dwg D3535

Dwg Rev: 3

Prog Rev: B

2-Deburr if necessary

AB 07-07-21

10

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



1B 67-67-24

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

07/07/23

can't

NO

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Deburr if necessary

Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326.

Identify as D3535-41

Form Joggle on brake using Jig DT8158 as per Dwg D3535

FF 07-07-23 10

FF 07-07-24 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/07/25
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/9/2007 3:47:41 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 33440

Part Number: D353539

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Er 07/07/24

carls
(10)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

BK/mj 07-07-25

(10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

F-2 07/07/25

(10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FP-16

m-l 07/07/25

(10X)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SAK/25

Job Completion



Paul

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr.	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

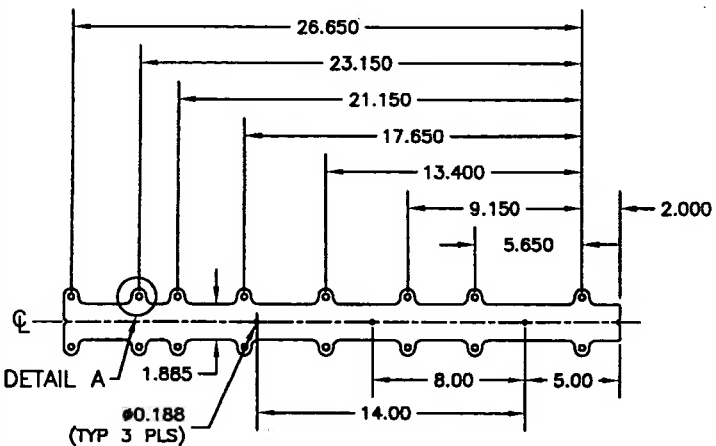
NOTE: Date & initial all entries

DART

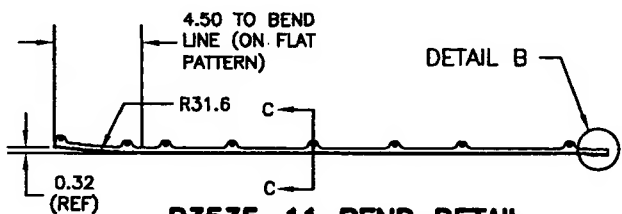
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07.04.24

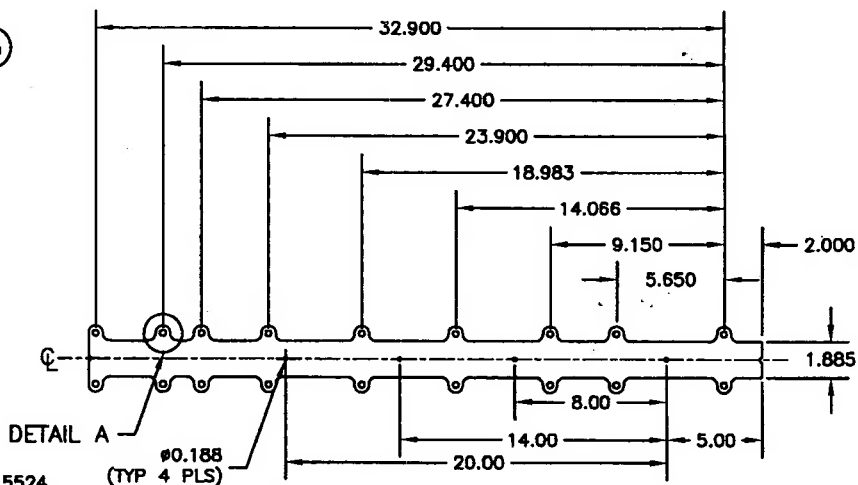
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CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D3535
DATE	TITLE	SHEET 1 OF 7
07.04.17	WEARSHOE	SCALE
		1:10
A	06.10.25	NEW ISSUE
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC



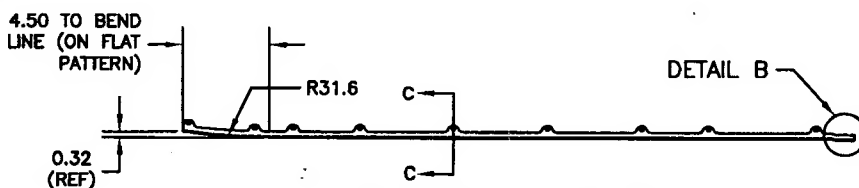
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

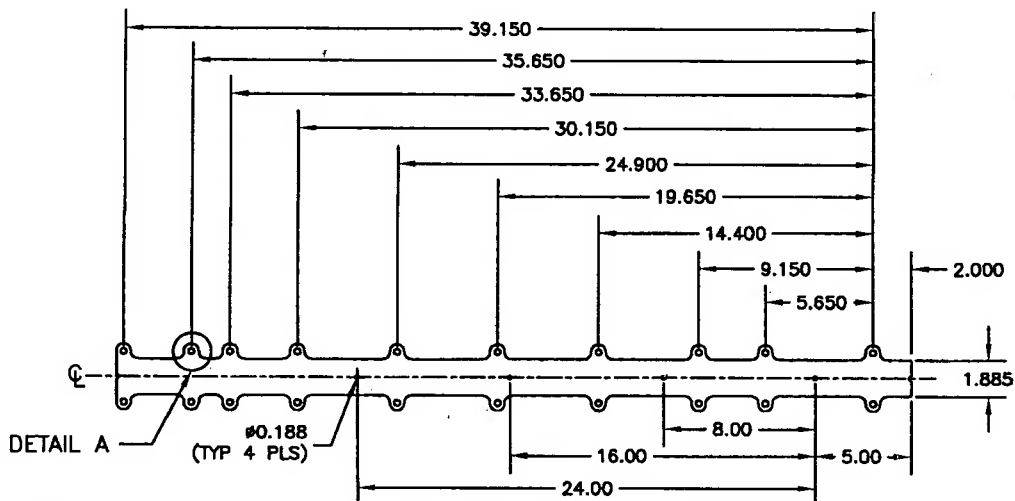
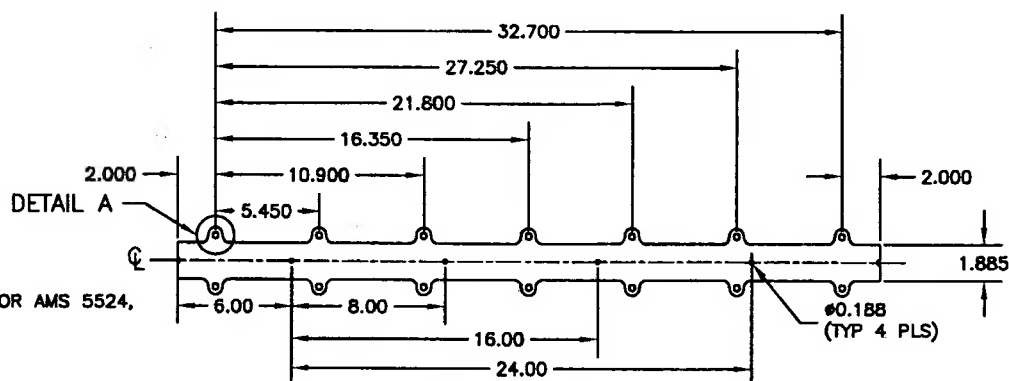
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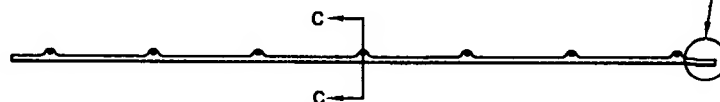
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		D3535	
DATE	TITLE	WEARSHOE	SCALE
07.04.17			1:10

**D3535-15F FLAT PATTERN**4.50 TO BEND
LINE (ON FLAT
PATTERN)0.32
(REF)**D3535-15 BEND DETAIL****D3535-21F FLAT PATTERN**

DETAIL B

**D3535-21 BEND DETAIL**

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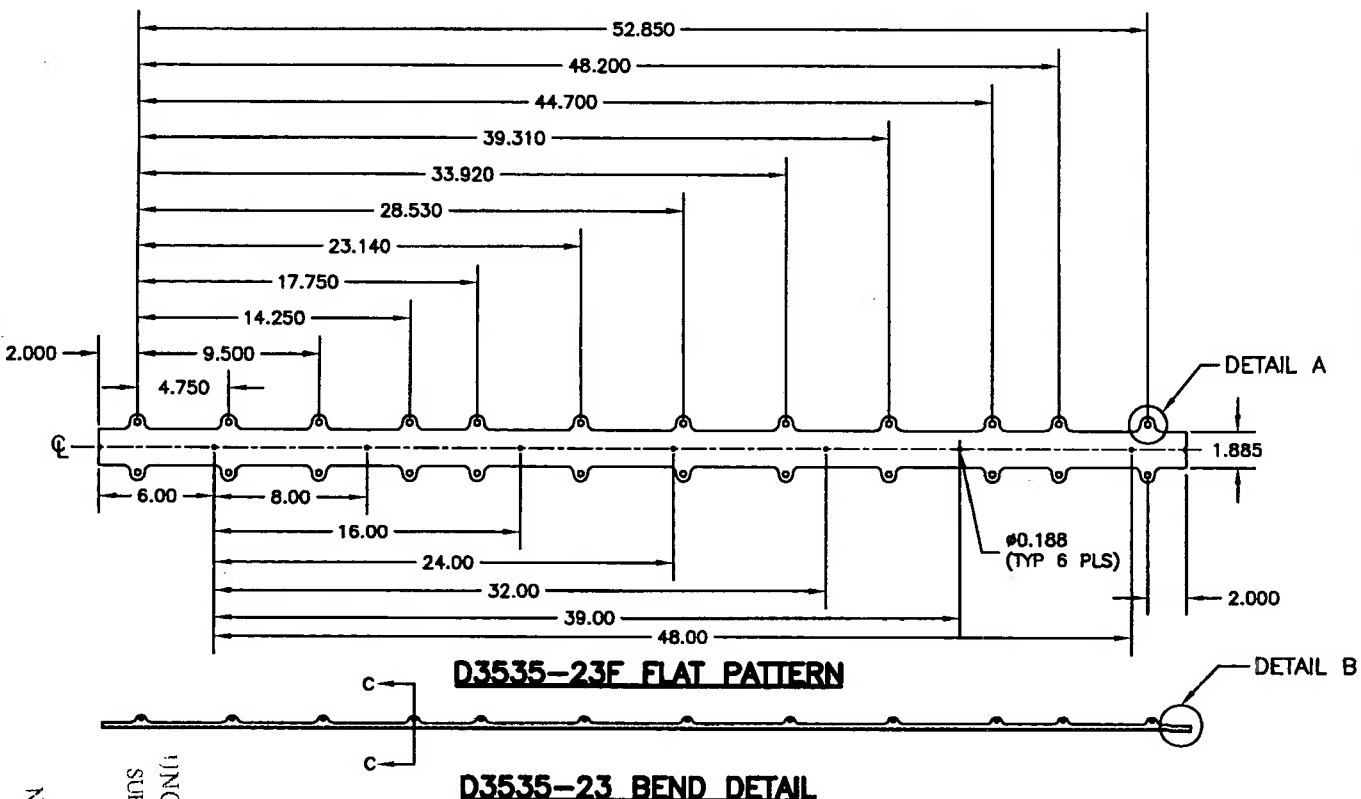
NOTES

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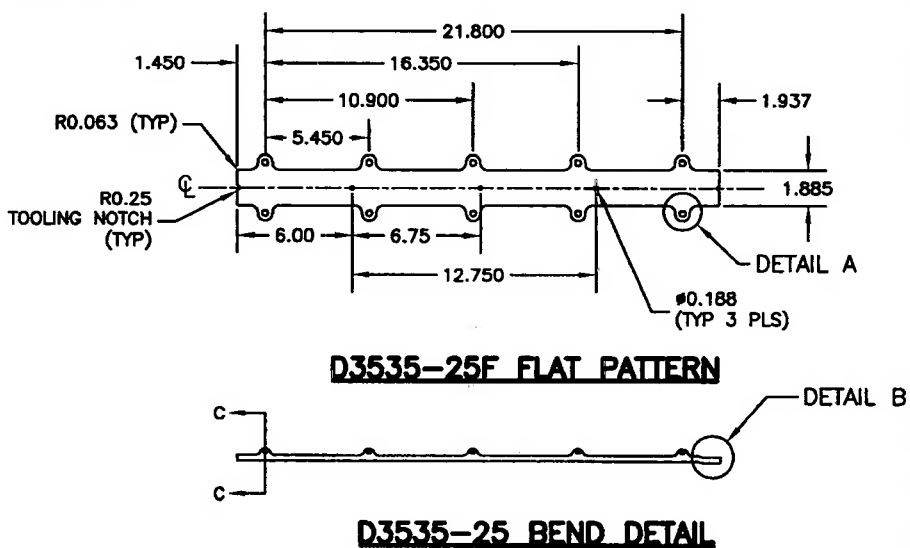
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**D3535-23F FLAT PATTERN****D3535-23 BEND DETAIL**

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NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
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**D3535-25F FLAT PATTERN****D3535-25 BEND DETAIL**

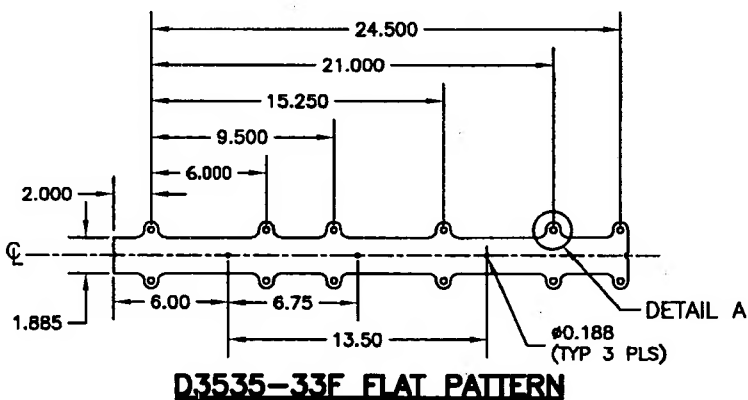
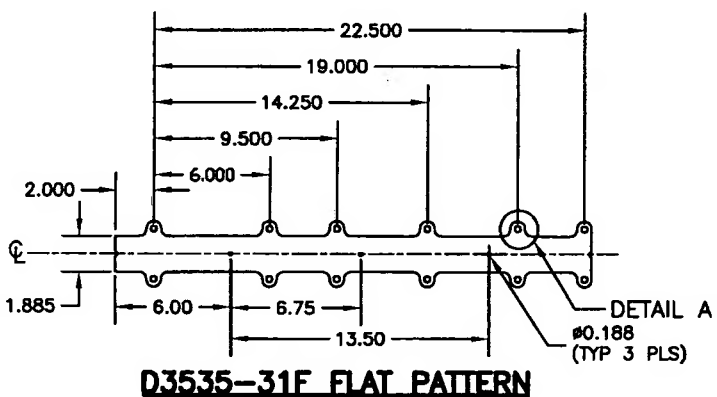
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CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
#	#	D3535
DATE	TITLE	REV. B
07.04.17	WEARSHOE	SHEET 3 OF 7
		SCALE
		1:10

DART

DESIGN	C B	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 4 OF 7
		SCALE	1:10	

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07.04.17



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NOTES

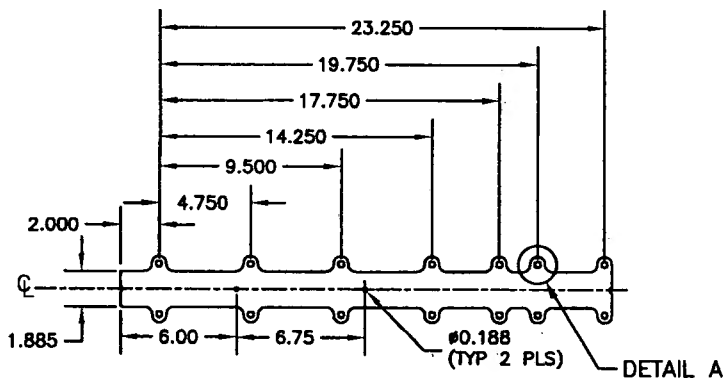
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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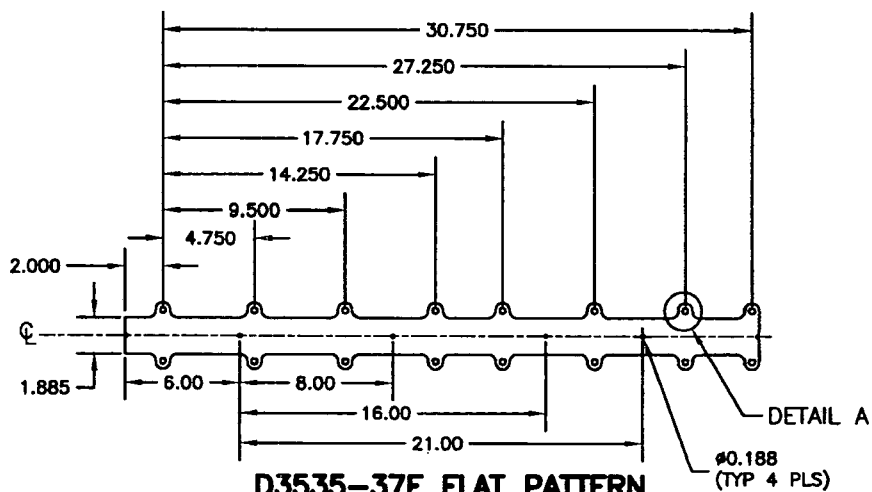
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DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 5 OF 7
		SCALE	1:10	



D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

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NOTES

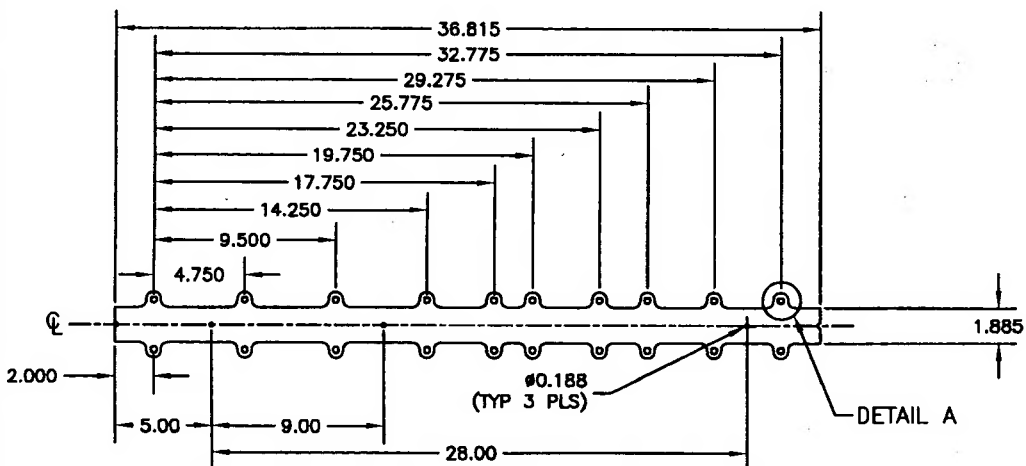
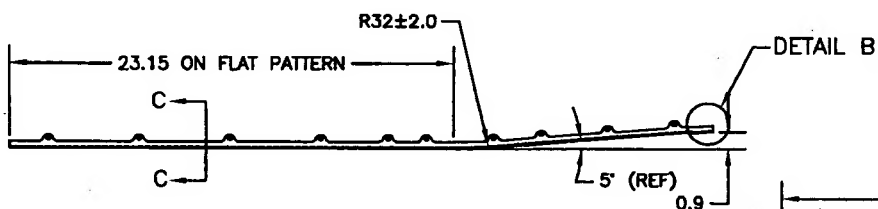
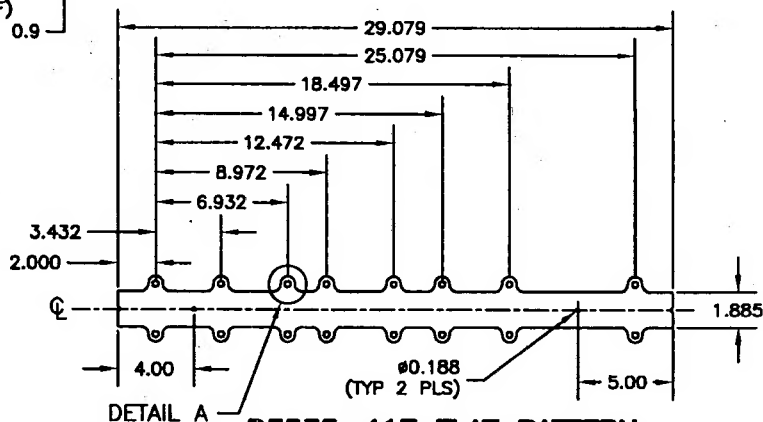
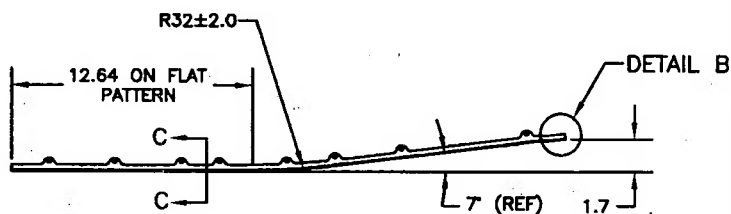
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CB	PH	PORT HADLOCK, WA	
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DATE		D3535	SCALE
07.04.17		WEARSHOE	1:10



**D3535-39F FLAT PATTERN****D3535-39 BEND DETAIL****D3535-41F FLAT PATTERN****D3535-41 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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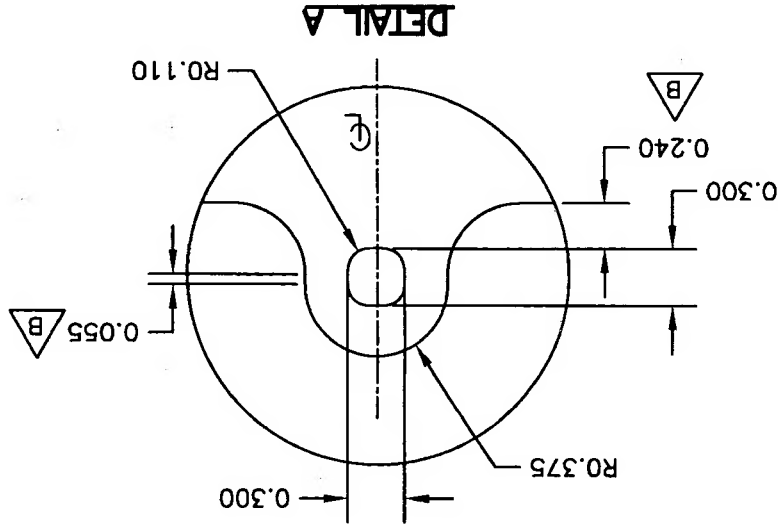
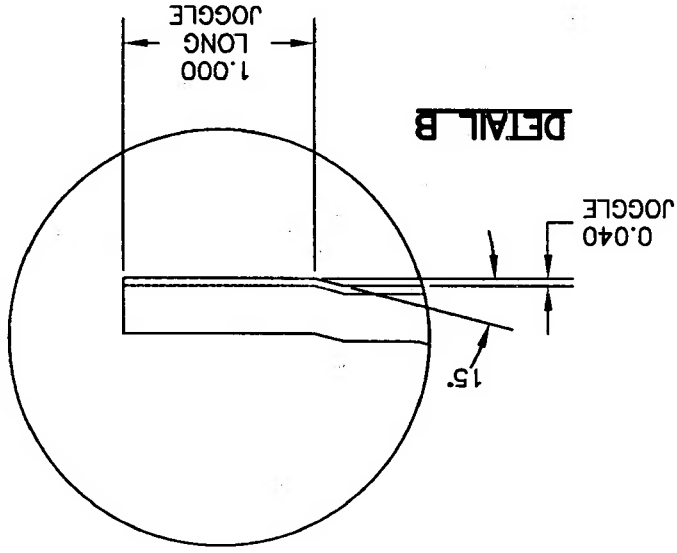
WORK
3/24/20

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CHECKED 	APPROVED 	DRAWING NO. D3535	REV. B	SHEET 7 OF 7
DATE 07.04.17	TITLE WEARSHOE		SCALE 1:1	

RELASED

07.04.24



SECTION C-C

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WORK ORDER
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
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DART AEROSPACE LTD		Work Order:	33440
Description: WEAR SHOE		Part Number:	D 3535-39
Inspection Dwg:	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
36.815	+/- .010	36.815	X			
32.775	+/- .010	32.775	*			
29.275	+/- .010	29.275	*			
25.775	+/- .010	25.775	*			
23.250	+/- .010	23.250	*			
19.750	+/- .010	19.750	*			
17.750	+/- .010	17.750	*			
14.250	+/- .010	14.250	*			
9.500	+/- .010	9.500	*			
4.750	+/- .010	4.750	*			
2.00	+/- .030	2.00	*			
9.00	+/- .030	9.00	*			
1.885	+/- .010	1.888	*			
28.00	+/- .030	28.00	*			
Ø .188	+ .005 - .001	.190	*			
Ø 300X300	+ .006 - .001	.304X304	*			

Measured by: HB	Audited by: 	Prototype Approval:
Date: 07-07-21	Date: 07/07/23	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

